	e <b>r ID 75605</b> ober 26, 2011 2:01:03 PM	1	*756	305*			Page 1
Revision ID: Item Name:	D3372-041  Collective Lock Assembly  10/26/2011 Start Qty: 10/27/2011 Req'd Qty	1.00 <b>*1*</b>	Accept	*N90004  Cust Item ID: Customer:	40100*	Setup Start Stop	17.21
Approvals:	Process Plan:		Tooling: _ SPC (Y/N):	Date: Date:		Run Start Stop	"NRT"
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID To	ool# Plan Accep Code Qty		Reject \ Insp. Number Stamp
Draw Nbr	Revision Nbr						
D3372	Rev B					~	
100 *100* Small Fab Small Fab	Fa	emo bricate D3372-3 using AN5-42A bolt entify as D3372-3	0.00 0.00 as per Dwg D3372	-	4	Bu/10,	/27 (D)
* <b>1 1                                 </b>		art completeness to step on W/O emo	0.00	Sp Illes la	7 <u>(</u>	<u>)</u>	
120 <b>*120*</b> Small Fab	Small Fab	· ·	0.00			·	

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as

D3369-5

Small Fab

So ula/27

a .

Work Orde Wednesday, Oct			M		*75605*					Page			Page 2	
Item ID: Revision ID: Item Name:	D3372-041 Collective Lo	ck Assembly				Accept	*N90	<b>0040</b>	100	<b>)</b> *	Setup	Start Stop	1 71	S1*
Start Date: Required Date: Reference:	10/26/2011	Start Qty Req'd Qt			*1* *1*		Cust Iten Custome					•	"N	S2*
Approvals:		an:		_				Date:				Start Stop	"IV	R1* R2*
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab	,	1 2 0 7	Memo I-Assemble 262 to the th Qty A/R N/A dentify as I	nreads Part Number A Loc	Description oktite 262 <u></u>	Set Up/ Run Hours 0.00 0.00 3372. Apply a drop of pe	Tool ID	# looT	Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
*140 *140* Large Fab Large Fab		T		ock shaft as p S Rod Ba	er Dwg D337 atch <u>/// [[4</u>	0.00 0.00 299				_E	_1,	1-10	-27	

2.5		
4		

Work Ord Wednesday, Och				*7	′5605*					Page 3
Item ID: Revision ID:	D3372-041			Accept	*N900	<b>040100</b>	<b>)*</b> Setu	p Start	*N.S	<b>31</b> *
Item Name:	Collective Lo	ck Assembly						Stop	*NS	32*
Start Date:	10/26/2011	Start Qty: 1.00	*1*		Cust Item II	D:				
Required Date	: 10/27/2011	Req'd Qty: 1.00	*1*	*	Customer:	•				
Reference:	- — — — — — — — — — — — — — — — — — — —						Run	Start	-i- B	<b>.</b> 4 J.
Approvals:	Process Pla	an:	Date:	Tooling:	Da	te:	Kun		*NH	₹1*
	QC:		Date:	_ SPC (Y/N)	): Da	te:		Stop	*NF	<b>?</b> 2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Ho		Tool # Plan Code	-			Insp. Stamp
150		QC9- Inspect visual per (	QSI004- Fusion Welds	0.00						-
*150* QC Quality Control		Memo		0.00	(/11.10.	<b>2</b> 7	(1x)			
160		QC5- Inspect part comple	eteness to step on W/O	0.00						
*160* QC Quality Control		Мето		0.00	11/10/77		(W)			
		2								
170		Identify as per dwg & Sto	ck Location:	0.00	CS09A			' - d		
*170* Packaging Packaging		Memo		0.00			_/hul:	274		

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Work Orde Wednesday, Oct				*756	305*							Page 4
Item ID: Revision ID: Item Name:	D3372-041 Collective Loc	k Assembly		Accept	*N900	<b>040</b>	100	ገ*	Setup	Start Stop	1/1	S1* S2*
Start Date: Required Date: Reference:	10/26/2011 10/27/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ite:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II 180 *180* QC Quality Control	)	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	y	Reject Number M (O	Insp. Stamp  27

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## **Picklist Print**

Wednesday, October 26, 2011 2:01:03 PM

Work Order ID:

75605

Parent Item:

D3372-041

Parent Item Name:

Collective Lock Assembly

**Comments:** 

IPP Rev:A Removed from 9 Digit 06-01-13 JLM

IPP Rev:B Added Key ID

06.03.21

EC

IPP Rev:C added D3384-043 DD

6061 Law 2000 to 1.500 Start Qty: 1.00

Start Date: 10/26/2011

Required Date: 10/27/2011 Required Qty: 1.00

	10.05.13 verified:	EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
5/16WC		Purchased	No			100	Each	2,554.0000	2 /	2/2/	7		
SS Flat Washer 5/16 FW5	51681								4	2////	0/27		
				<b>Location</b>		Loc Qty	Lo	c Code			/		
				ST377		2554			/				
					072	79							
					174	53			_ &				
					643 332	261 1161							
					343 *	1000		•					
AN5-42A Bolt		Purchased	No			100	Each	20.0000	1	B	1/10/0	27	
				<b>Location</b>		Loc Oty	Lo	c Code			/ /		
				ST340	*	20							
				108	442	20					2. /		
<b>AN960-416</b> Washer	NAS1149F0463P	Purchased M116702	(JV)			100	Each	0.0000	2	J.	11/10/	27	
<b>D2728-7</b> Dart Logo label		Manufactured	$\mathcal{C}_{N_0}$			100	Each	0.0000 پېر	0		34/L	0/27	7
<b>D3372-1</b> Main Body		Manufactured	No			100	Each	2.0000	1	1_	/S/1/	10/	27
				Location		Loc Qty	Loc	c Code			/ /	•	
				GA 700	38	2 2	B	75124	/				
D3372-5 Cam Lock Shaft		Manufactured	No			100	Each	3.0000	1	1	///	Job	7
				Location		Loc Qty	Loc	Code					
				ST048		3			Ai				
				700:	35	3							

Wednesday, October 26, 2011 2:01:03 PM

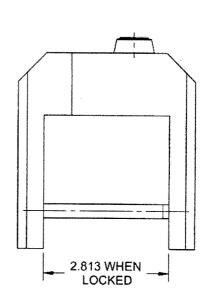
Work Order ID: 75605 Parent Item: D3372-041 Start Date: 10/26/2011 **Required Date:** 10/27/2011 Parent Item Name: Collective Lock Assembly Start Qty: 1.00 Required Qty: 1.00 D3372-7 No Manufactured 100 Each 3.0000 Slider Body Location Loc Qty Loc Code ST492 3 69633 70036 2 D3373-1 No-100 Each Manufactured 25.0000 Gam Lock Location Loc Qty Loc Code ST049 25 58463 5 74862 20 D3384-043 Manufactured 100 No Each 7.0000 Cyclic Sock Assembly Location Loc Qty Loc Code ST480 3 74729 3 ST486 70037 HX-81 Purchased No 100 Each 17.0000 1/4"-20 SHCS 3/8" long Location Loc Qty Loc Code ST390 17 114383 17

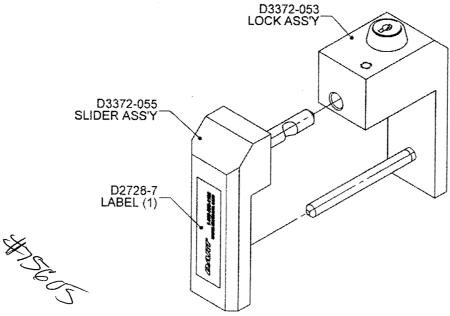
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CHECK	ED APPROVED	DRAWING NO. D3372	REV. B
DATE	W	TITLE	SCALE
1	05.02.23	COLLECTIVE LOCK	1:2
Α	05.01.10	NEW ISSUE	
В	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK D3369-5 SUPERCEDES D3372-11 (OBSOLETI	









## D3372-051 AS350 COLLECTIVE LOCK ASS'Y

#### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2) ALL DIMENSIONS ARE IN INCHES

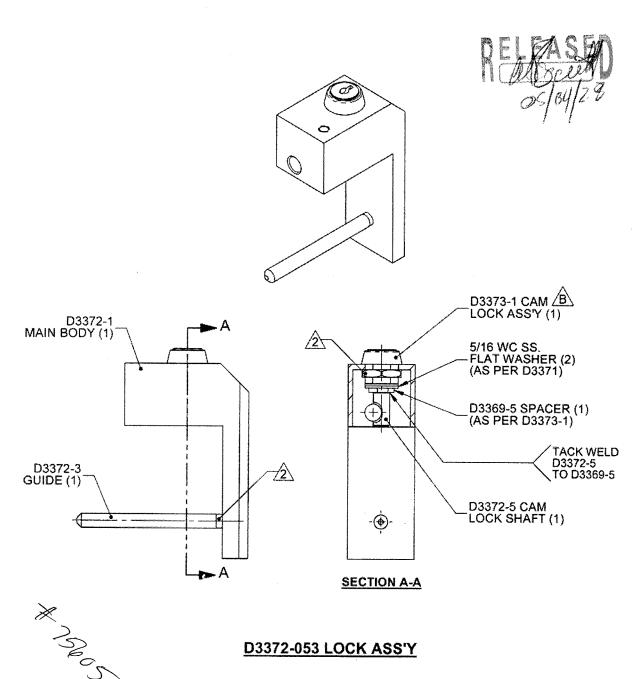
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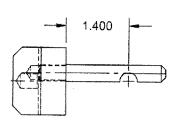
#### NOTES:

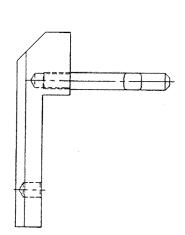
- 1) WELD PER DART QSI 004 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

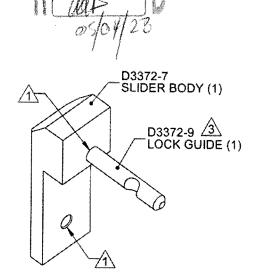
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DESIGN	DRAWNBY	DART AEROSPAC HAWKESBURY, ONTARIO, O	
CHECKED 事	APPROVED	DRAWING NO. D3372	REV. B
DATE		TITLE	SHEET 3 OF 8
05	.02.23	COLLECTIVE LOCK	SCALE 1:2







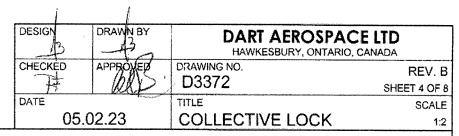


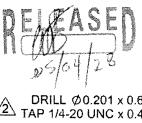
## **D3372-055 SLIDER ASS'Y**

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
  2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
  3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES

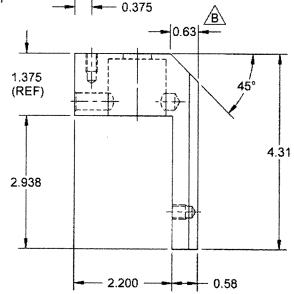


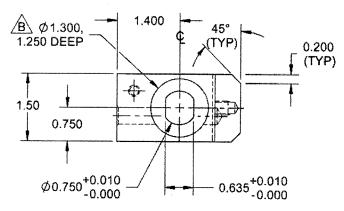






2,108 DRILL "I" DRILL x 0.525 DEEP THREAD 5/16-24 UNF x 0.300 DEEP 0.750-







## D3372-1 MAIN BODY

1.125

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
  (REF. DART SPEC. M6061T6B)
  2) COVER INSIDE HOLES PRIOR PAINTING
  3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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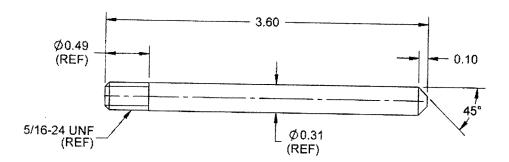
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DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, 6	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B
DATE			SHEET 5 OF 8
I	ດວັດວ	TITLE	SCALE
1 05.	.02.23	COLLECTIVE LOCK	1:1

# SPECIFICATION CONTROL DRAWING







## **D3372-3 GUIDE**

#### NOTES:

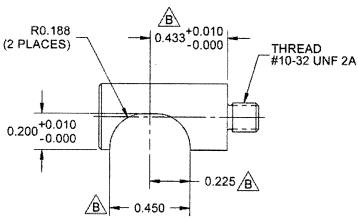
- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN. 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

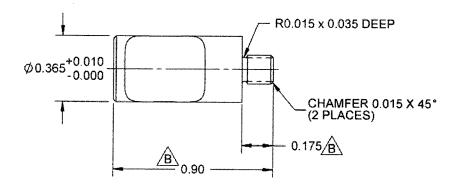
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杜		D3372	SHEET 6 OF 8
DATE		TITLE	SCALE
05	.02.23	COLLECTIVE LOCK	2:1









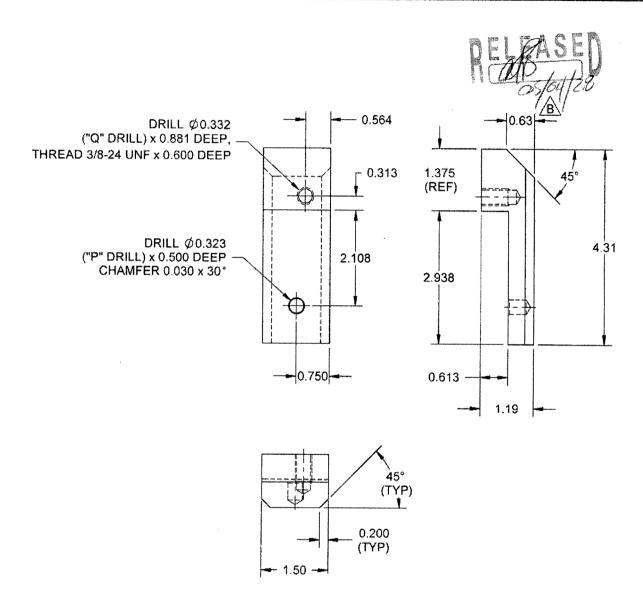
## **D3372-5 CAM LOCK SHAFT**

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DESIGN	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, (	
CHECKED	APPROVED	DRAWING NO.	REV. B
15	1412	D3372	SHEET 7 OF 8
DATE	001-	TITLE	SCALE
05	.02.23	COLLECTIVE LOCK	1:2



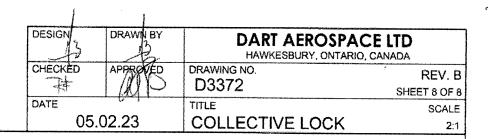
## D3372-7 SLIDER BODY

#### NOTES:

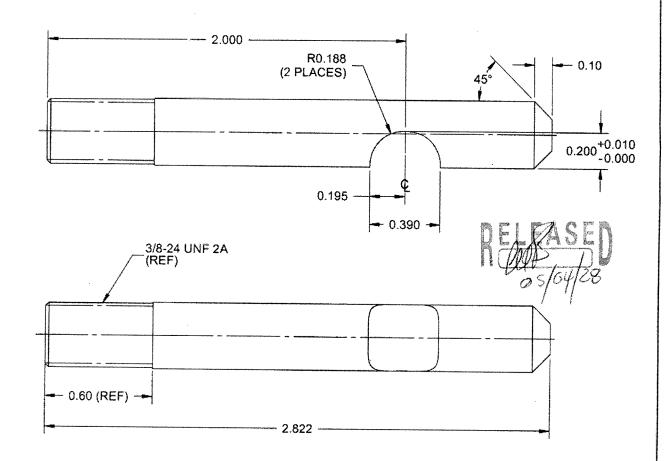
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
  (REF. DART SPEC. M6061T6B)
  2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) ALL DIMENSIONS ARE IN INCHES
  5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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## **SPECIFICATION CONTROL DRAWING**



## D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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